

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 66904

Wednesday, March 02, 2011 1:46:53 PM

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Item ID: D4191-5	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Access Cover				
Start Date: 3/2/2011	Start Qty: 2.00		Cust Item ID:	
Required Date: 3/25/2011	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		B.A 11/03/28		2	0		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		cmf 11/04/27		2	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2		BR 11-4-27	

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Work Order ID 66904

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Item ID: D4191-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Access Cover

Start Date: 3/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				2	φ	all	«104/27
170 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
180 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							4/12/18 (2)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 66904

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Item ID: D4191-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Access Cover

Start Date: 3/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD 2334

11-07-18
G

POSITIVE RECALL

EFFECTIVE 11/3/02 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, March 02, 2011 1:46:49 PM

Work Order ID: 66904



Parent Item: D4191-5



Parent Item Name: Access Cover

Start Date: 3/2/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X02.00 0		Purchased	No			100	f	21.8023	0.166	0.349474			



22 11/03/23

6061-T6 Bar .375 x 2.00

Location

Loc Qty

Loc Code

MAT

20

114488

20

MAT01

1.8023

19059

1.8023

.35

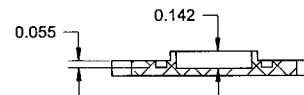
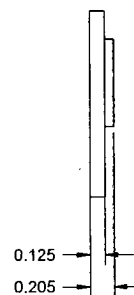
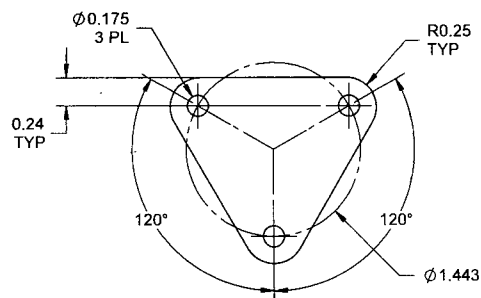
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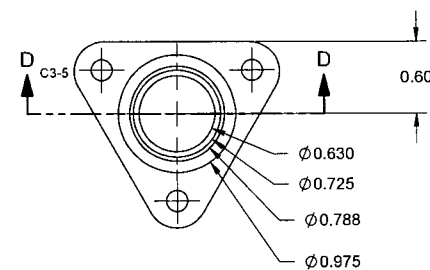
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SECTION D-D C4-5



CD11103102
W10'66904

D4191-5 ACCESS COVER

PRELIMINARY ISSUE

10.11.17

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8
OR AMS 4160
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA6
MFG. APPR.		D4191	SHEET 5 OF 12
APPROVED		TITLE	SCALE
DE APPR.		CONTROL BOX	NTS
DATE	10.11.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 66904
Description: ACCESS COVER		Part Number: D4191-5
Inspection Dwg: D4191 Rev: PAG		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.142	+/- .010	0.135	✓		D-G	GA-08
0.055	+/- .010	0.056	✓		Vern	GA-01
φ 0.175	+ .005 / - .001	φ 0.178	✓		"	"
0.24	+/- .030	0.239	✓		"	"
120°	+/- 1/2°	120°	✓		Angle proto	ML-EBB
120°	+/- 1/2°	120°	✓		"	"
φ 1.443	+/- .005	φ 1.443	✓		Vern	GA-01
R0.25	+/- .030	R0.250	✓		R-G	ref.
0.125	+/- .010	0.127	✓		Vern	GA-01
0.205	+/- .010	0.206	✓		"	"
0.60	+/- .030	0.598	✓		"	"
φ 0.630	+ .008 / - .001	φ 0.630	✓		"	"
φ 0.725	+ .008 / - .001	φ 0.726	✓		"	"
φ 0.788	+ .010 / - .001	φ 0.787	✓		"	"
φ 0.975	+ .010 / - .001	φ 0.977	✓		"	"

Measured by: H.A	Audited by: <i>amf</i>	Prototype Approval:
Date: 11/03/28	Date: 11/04/27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

